

Work Order ID 127941

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127941

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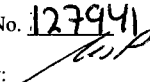
Item ID: D2571 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Fwd, Out
 Start Date: 19/12/2014 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 24/12/2014 Req'd Qty: 8.00 ***8*** Customer:
 Reference: 

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2571	F

100 HAAS CNC VERTICAL MACHINING #1 0.00 ***100*** **8** **φ** **DAS 40 9-89 JFC 2015-01-10**
 HAAS 1
 HAAS CNC vertical machine #1
 Memo
 Program Batch No. **127941**

Double check by: 
 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect

110 CONVENTIONAL MILLING MACHINE 0.00 ***110*** **8** **φ** **JFC 2015-01-10**
 Mill Conv
 Conventional Milling Machine
 Memo
 Machine keyway as per dwg D2571 & D2572

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[illegible]

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 Start Date: 19/12/2014 Start Qty: 8.00 ***8*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>11/12/14</i> Memo START TIME: <i>9:30</i> OVEN TEMPERATURE: <i>220</i> FINISH TIME: <i>10:00</i>	0.00 0.00				<i>8.0</i>	<i>15-1-30</i>		<i>23 88</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(8)</i>			<i>DAS 38 9-88</i> JAN 30 2015
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>5397</i> Memo	0.00 0.00				<i>8</i>		JAN 02 2015	<i>DAS 06 8-88</i>

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Item ID: D2571

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Fwd, Out

Start Date: 19/12/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 24/12/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

ML5 150203mf
15-2-2

Picklist Print

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Work Order ID: 127941

127941

Parent Item: D2571

D2571

Parent Item Name: Saddle, Fwd, Out

Start Date: 19/12/2014

Required Date: 24/12/2014

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: I02.10.02Re-format; Change to Dwg Rev. D & incorporated
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	60.0000	1	8			DAS
D6101-007									**			14/12/18	40
Saddle Billet													9-89

Location

Loc Qty

Loc Code

MAT041

1

121646

1

MAT044

59

114363

12

→ 116083

25

119005

2

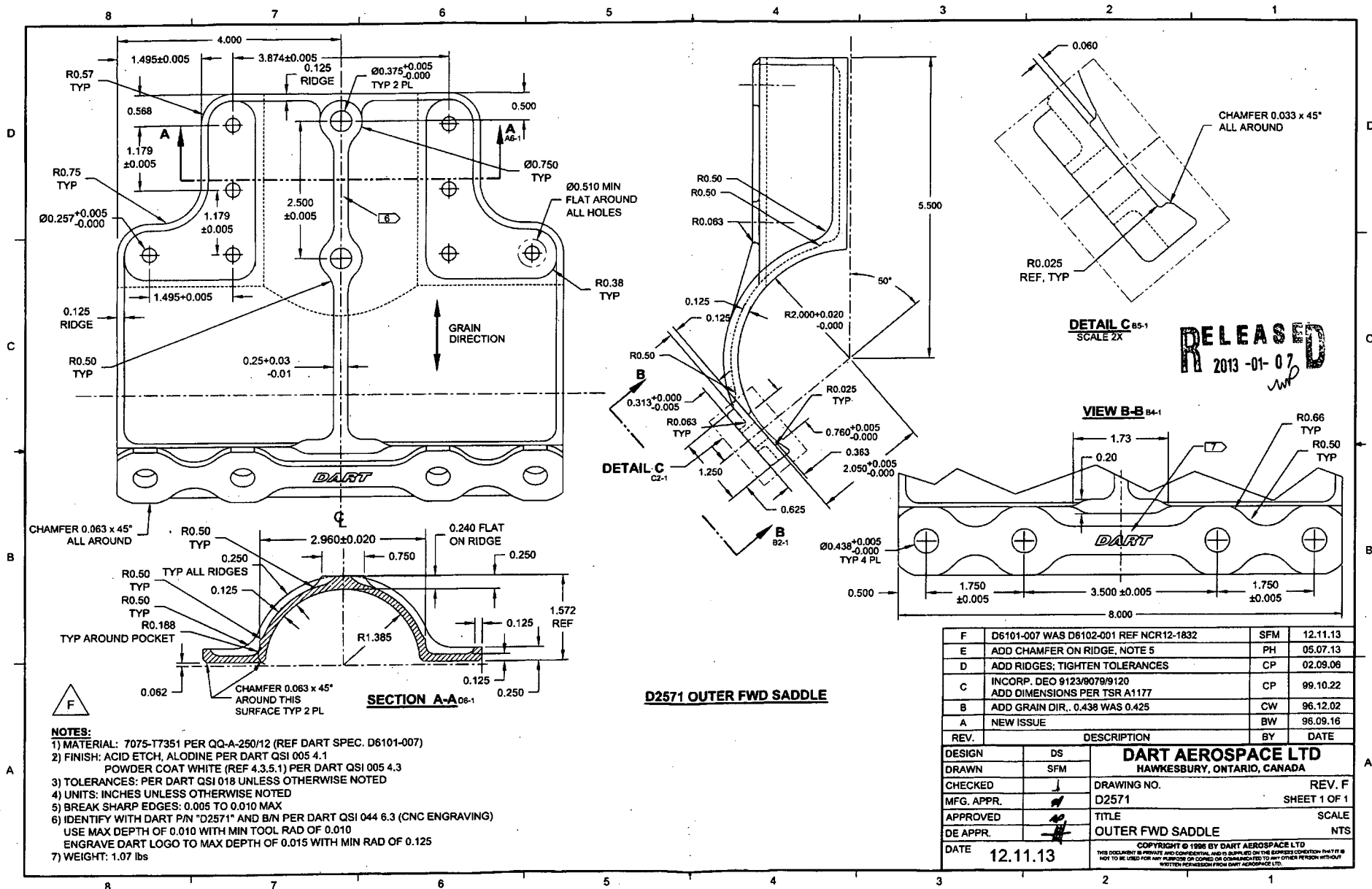
120494

19

76839

1

8



NOTES:

- 1) MATERIAL: 7075-T7351 PER QQ-A-250/12 (REF DART SPEC. D6101-007)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2571" AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USE MAX DEPTH OF 0.010 WITH MIN TOOL RAD OF 0.010
ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD OF 0.125
- 7) WEIGHT: 1.07 lbs

F	D6101-007 WAS D6102-001 REF NCR12-1832	SFM	12.11.13
E	ADD CHAMFER ON RIDGE, NOTE 5	PH	05.07.13
D	ADD RIDGES; TIGHTEN TOLERANCES	CP	02.09.06
C	INCP. DEO 9123/9079/9120 ADD DIMENSIONS PER TSR A1177	CP	99.10.22
B	ADD GRAIN DIR., 0.438 WAS 0.425	CW	96.12.02
A	NEW ISSUE	BW	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SFM		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2571	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		OUTER FWD SADDLE	NTS
DATE	12.11.13	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD	Work Order:	127941
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.439	0.440	0.439	0.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	7.999	8.000	8.000		
F	0.490	0.510		0.503	0.500	0.504	0.504		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.376	0.376	0.376		
I	0.490	0.510		0.501	0.5005	0.500	0.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.570	0.570	0.567	0.565		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.133	0.133	0.133	0.133		
Q	0.115	0.135		0.126	0.1275	0.130	0.128		
R	0.240	0.260		0.251	0.255	0.254	0.253		
S	0.115	0.135		0.127	0.130	0.129	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.237	0.235	0.247		
W	0.115	0.135		0.120	0.120	0.120	0.124		
X	0.308	0.313		0.3125	0.312	0.312	0.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.367	0.367	0.367	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.617	0.627	0.628	0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.248	0.246	0.250		
AE	1.375	1.395		1.3886	1.3915	1.3935	1.3877		
AF	0.115	0.135		0.128	0.130	0.130	0.130		
AG	0.240	0.280		0.265	0.270	0.270	0.270		
AH	0.240	0.260		0.248	0.247	0.247	0.251		
AI	2.000	2.020		2.0004	2.005	2.0065	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by: 40 9-89 JFC	Audited by: DAS
Date: 2015-01-10	Date: 14 9-89 15/01/23

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 12794
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	45	26	87	48		
A	0.438	0.443		0.439	0.439	0.439	0.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.502		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	8.001	7.999		
F	0.490	0.510		0.503	0.503	0.503	0.500		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.500	0.500	0.500	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.566	0.566	0.566	0.565		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.133	0.133	0.133	0.133		
Q	0.115	0.135		0.127	0.127	0.126	0.125		
R	0.240	0.260		0.254	0.254	0.253	0.255		
S	0.115	0.135		0.132	0.132	0.132	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.240	0.240	0.239		
W	0.115	0.135		0.122	0.122	0.123	0.120		
X	0.308	0.313		0.312	0.312	0.312	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.361	0.363	0.358	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.626	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.250	0.252	0.246		
AE	1.375	1.395		1.3872	1.3885	1.3864	1.3892		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.270	0.270	0.270	0.270		
AH	0.240	0.260		0.249	0.249	0.250	0.248		
AI	2.000	2.020		2.001	2.001	2.003	2.0039		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: JFC	Audited by: 68-6
Date: 2015-01-11	Date: 15/01/23

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
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D	05.05.05	Added dimension AI	KJ/RF	
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